PLASKOLITE

TRAINING IN THE MOMENT
OPTIX® PURGE
Extrusion Purge Instructions

The following steps are recommended when cleaning an extruder with OPTIX Purge. These are general guidelines and may require adjustments for your process.

Step	Instructions	Special Instructions
1.	**Drain** the production resin from the extruder system completely.	
2.	**Clean** the feed-section.	
3.	**Run** the barrel empty.	
4.	**Remove** equipment such as the screen changer, melt pump, & die.	
5.	**Increase** the temperature on all zones (excluding the feed zone) to 480°F (249°C) - 500°F (260°C).	Best results observed at 500°F (260°C) to 520°F (271°C). Do not exceed 550°F (288°C).
6.	**Block** the extruder vent to maintain internal system pressure.	Applicable only for vented extruders.
7.	**Switch** the extruder to maintenance or purge mode.	
8.	**Add** OPTIX Purge continuously into the barrel at low extruder screw speeds until the exdrudate discharges.	Variation in extruder speeds helps OPTIX Purge break the chemical chain on the surface of the screw and inner walls of the barrel.
9.	**Increase** the extruder screw speed for a few minutes.	
10.	**Decrease** the extruder screw speed for a few minutes.	
11.	**Repeat** steps 8 through 10 until discharge is consistently white with no carbon/char residue.	
12.	**Flush** the barrel with OPTIX Purge at normal speeds.	If disassembling the screw, let the screw cool down to optimum temperature to easily chip off any residue from the surface.

DO NOT run OPTIX Purge through screen changers, melt pumps, & dies.

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